

Date: Thursday, 5/4/2006 1:09:26 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DUCT
 Job Number : 27017
 Estimate Number : 12315
 P.O. Number : N/A Part Number : D34731
 This Issue : 5/4/2006 S.O. No. : N/A Drawing Number : D3473 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : A
 Previous Run : 26117 Material : N/A
 Written By : SEE LJ COMMENT BELOW Due Date : 5/28/2006 Qty: 6 Um: Each
 Checked & Approved By : 06.05.05
 Comment : Est Rev:A New Issue 06-03-02 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S26GA 304/316 0.018 SHEET



Comment: Qty.: 0.6305 sf(s)/Unit Total : 3.7832 sf(s)

304/316 0.018 SHEET

Batch: M101000

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

Cut as per Dwg D3473

Dwg Rev: A6

Prog Rev: A

SAD 06.05.19 (6)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M 06 05 19 (6)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

06.05.23 (5) 970

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary.

2-Roll as per Dwg D3473

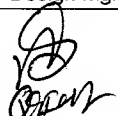
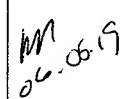
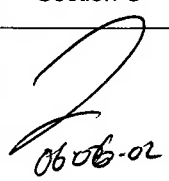
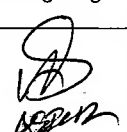
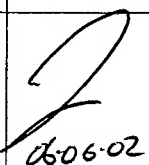
3-Form Small Flange as per Dwg D3473 using DT8861 Base & Dt8847B Male Die


SB 06/06/03 (5)

SB 06/06/03 (5)

SB 06/06/03 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-06-02	4	1 part went missing. from water set shelf to Inspection shelf. P&SS me off.		Count now at 5. Parts to be verified for Qty, and taped together.	 06-06-02	 06-06-02		 06-06-02

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/06/02

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DUCT

Job Number: 27017

Part Number: D34731

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Form Large Flange as per Dwg D3473 Using DT8862

SB 06/06/03

5-Spot Weld as per Dwg 3473

SB 06/06/03

6.0

QC5/9

WELD INSPECTION



06/06/03

Comment: WELD INSPECTION

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 356

06/06/03

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/03

Job Completion



W 06/06/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

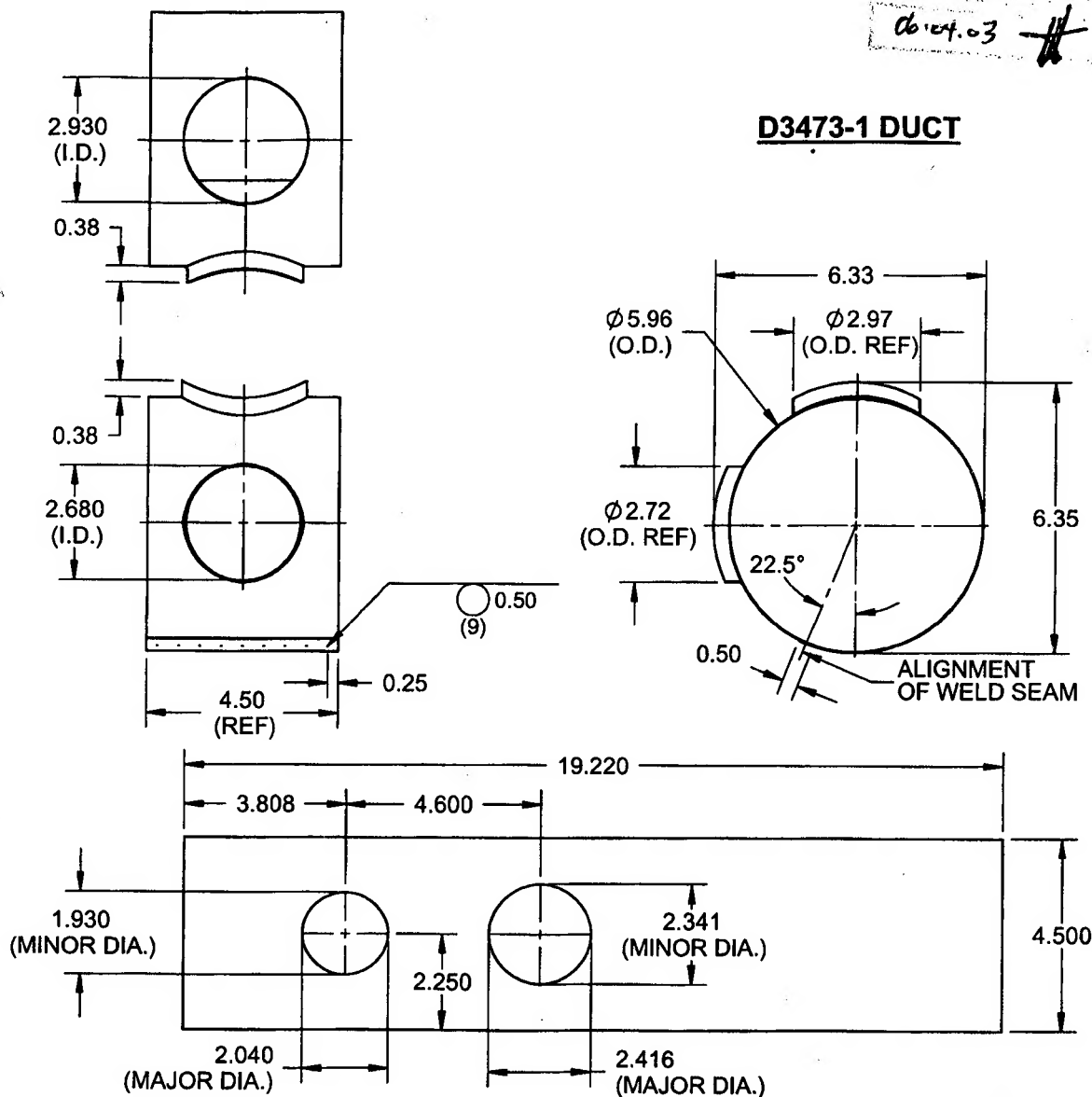
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

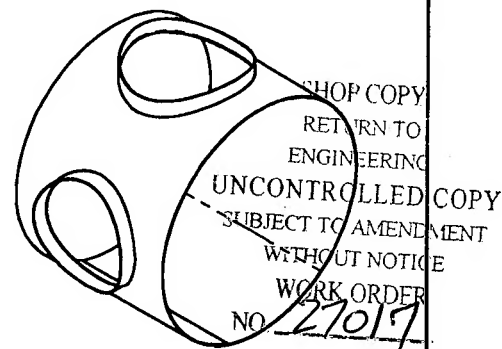
QA: N/C Closed: _____ Date: _____

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3473	REV. A SHEET 3 OF 7
DATE 06.02.07		TITLE BLOWER INLET ADAPTER	SCALE 1:4

**D3473-1F DUCT FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED)
2B FINISH 26 GAUGE SS (0.018 THICK)
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010



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